

5073524



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3560-041
Job Sheet 177708



Part No: D3560-041

Job Qty: 2 ea

Part Name: Arm Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/16/18

Job Tracking No:

Due Date: 5/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07.05.24 EC IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C
ECN1048 07-12-18 DD verified by: EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	5/23/18	5/23/18	0.00	0.00	Start Up Large Fab-4		CPC
140	Large Fab	2 pcs	5/23/18	5/23/18	0.00	1.63	Large Fab 2		CPC
150	QC	2 pcs	5/23/18	5/23/18	0.00	0.00	QC5		18-05-24
160	QC	2 pcs	5/23/18	5/23/18	0.00	0.00	QC9		18-05-24
170	HandFinish	2 pcs	5/23/18	5/23/18	0.00	0.25	HandFinish1		SA 18-05-24
180	QC	2 pcs	5/23/18	5/23/18	0.00	0.00	QC7-2		SA 18-05-24
190	Small Fab	2 pcs	5/23/18	5/23/18	0.00	0.06	Small Fab-4		SA 18-05-24
200	QC	2 pcs	5/23/18	5/23/18	0.00	0.00	QC5		SA 18-05-24
210	Packaging	2 pcs	5/23/18	5/23/18	0.00	0.00	Packaging3-1		SA 18-05-24
220	QC21-SA	2 Ea	5/23/18	5/23/18	0.00	0.00	QC21		SA 18-05-24

Part Op 140 - 1-Weld assembly as per dwg D3560 STEP: 1- clean material (buff bracket and bottom of arm with blue pad) 2- set
Descriptions: up bracket and arm on jig 3- preheat bracket and arm with torch 4- clean before welding with brush 5- set up machine to
135 amps 6- weld across bottom and top ends 7- reheat with torch (65 deg C) 8- on one side weld from bottom to top
half way 9- same for other side (half way) 10- from half way point weld the rest of the first side (ease off pedal near end)
11- same for remaining side (ease off pedal near end)
190 - 1-Press bushing in D3560 arm per dwg D3562
210 - *** STOCK IN STEP CELL *** LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3560-1	Arm	2 Ea (1 ea)	90-Start up Operation	5052472 → 2 F14944 → 2
D3592-1	Plate	2 Ea (1 ea)	90-Start up Operation	5063834 → 2 5061044 → 2
D2808	Spacer	2 Ea (1 ea)	190-Small Fab	F155607

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3560-1	2	4	0
	D3592-1	2	44	0
190-Small Fab	D2808	2	8	0

003354

Plex 5/16/18 1:40 PM Dart.Gagnon.Michelle



Container No: S073526



Part: D3560-041

Job No: 177708

Serial No/Batch: S073526

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/23/18